

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003368**Date Inspected:** 25-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG side, bottom and deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA performed 10% verification Magnetic particle Testing (MT) on the following fillet welds joining T-stiffeners to side and bottom panels on OBG section 4AE: SP-031, SP-031 (CWR), BP-017, SP-066, SP-054 and SP-078. All of the welds that were examined appeared to comply with AWS D1.5 2002 and the contract documents.

QA observed ZPMC qualified welding personnel FCAW R1 repair on SSD12-PP-028-129 following the guide lines of WPS-345-FCAW-1G (1F)-repair-1. QC monitored the weld repair process continuously until complete and recorded the repair on report# B-WR587. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 30 Amps: 310 Travel speed: 270mm/min

Welder ID: 068918

QA observed ZPMC personnel fitting diaphragms in the 2nd corner assembly for OBG. Component number could not be found marked on the piece.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

Other general observations include ZPMC personnel fitting and welding OBG east fixture, OBG temporary support columns, grinding and weld bevel prep on various OBG components.

### Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

---